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RBE332A94-3400-03-5
Job Sheet 191119

**Part No:** RBE332A94-3400-03-5**Job Qty:** 2 pcs**Part Name:** Sight Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/21/19**Job Tracking No:****Due Date:** 3/22/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD**Ship Via:****Bill of Materials**

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Container No: S168026**Part:** RBE332A94-3400-03-5**Job No:** 191119**Serial No/Batch:** S168026**Revision:** A**Inspector:****Exp Date:****Instructions:****Date:** 04/01/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/22/19		0.00	0.40	Small Fab - 1		ML
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/22/19		0.00	0.00	QC 5 - 10		APR 01 2019 DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	2 pcs	3/22/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	2 pcs	3/22/19		0.00	0.00	QC 21 - SA - 21		DAS 21 APR 01 2019
							QC 21 - SA - 70		
							QC 21 - SA - 53		

Part Op 100 - Assemble as per DWG. See note 8 and 9.

Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

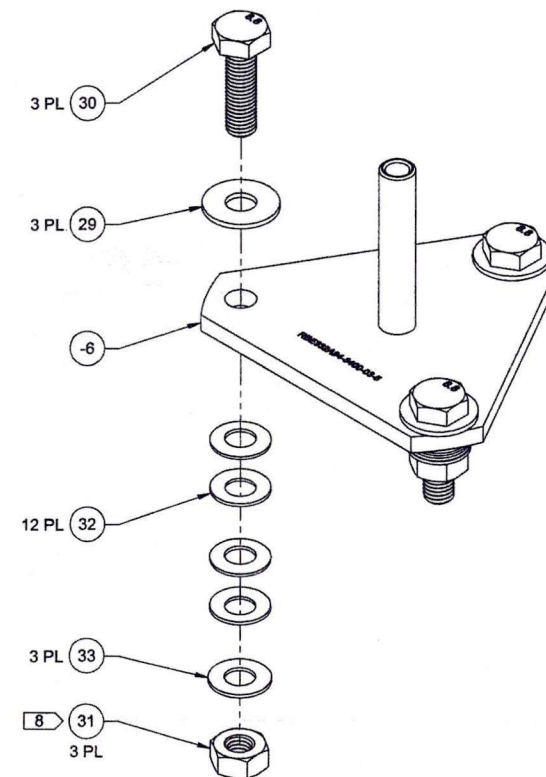
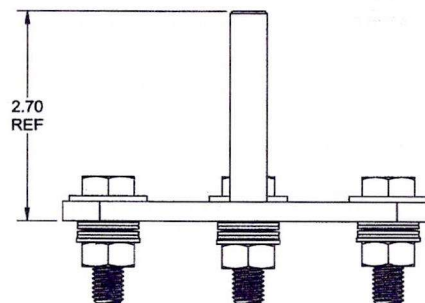
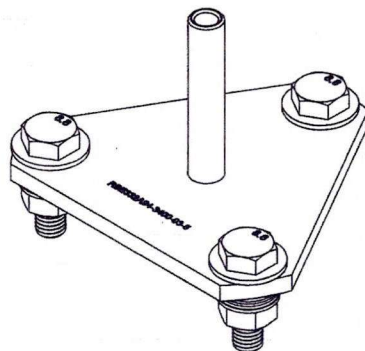
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
65 90591A171	Hex Nut	6 Ea (3 ea)	100-Small Fab - 1	FM138414-8
6a 91090A112	Zinc-Plated Steel Large-Diameter Flat Washer 3/8" Screw Size, 1" Od, .05"-.08" Thick (Mcmas)	6 (3 ea)	100-Small Fab - 1	5157263
70 91280A636	Hex Head Cap Screw	6 Ea (3 ea)	100-Small Fab - 1	5157274
58 96445K251	Steel Belleville Disc Spring 10.2mm ID. X 1.1mm THK.	24 (12 ea)	100-Small Fab - 1	5157244
40 98023A031	Yellow Zinc Plated Grade 8 Steel Washer 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.	6 (3 ea)	100-Small Fab - 1	5157242
RBE332A94-3400-03-6	Sight Support Weldment	2 pcs (1 ea)	100-Small Fab - 1	5105663

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A171	6	100	0
	91090A112	6	0	0
	91280A636	6	23	0
	96445K251	24	0	0
	98023A031	6	0	0
	RBE332A94-3400-03-6	2	0	0
Part Specifications				
Specifications could not be found.				

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ITEM #	QTY	PART #	PART TITLE
-6	1	RBE332A94-3400-03-6	SIGHT SUPPORT WELDMENT
29	3	McMaster#91090A112 OR EQUIV.	ZINC PLATED STEEL WASHER 0.406" ID. X 1.000" OD. X 0.056"-0.071" THK.
30	3	McMaster#91280A636 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
31	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
32	12	McMaster#96445K251 OR EQUIV.	STEEL BELLEVILLE DISC SPRING 10.2 mm ID. X 1.1 mm THK.
33	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.



RBE332A94-3400-03-5 SIGHT SUPPORT

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 31 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

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 WORK ORDER
 NO. 191119 MJS
 19-02-21

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBE332A94-3400-03	SHEET 6 OF 26
APPROVED	WY	TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	NTS
DATE 2/14/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					